Work Order II September-23-13 11:0			*10	714	16*						Page 1
Item ID: D293 Revision ID:	3-2		Accept	*/	1900(า4ก	100)* s	etup Star	* * N	S1*
**************************************	addle Right							,	Stop	"*N	S2*
Start Date: 9/23/	13 Start Qty: 4.00	*4*	N	•	Cust Item ID):					
Required Date: 9/23/	13 Req'd Qty: 4.00	*4*		•	Customer:			7			
Reference:							_	-			
Approvals: Proc	cess Plan: MC5	Date: 13-07-2	√ Tooling:		Dat	te:		ļR	tun Star	17	R1*
ĠĊ:	•	Date:	SPC (Y/N):	·	Dat	e:			Stop	" *N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	s	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								1		
D2933	Rev C	••									
*100 *100* HAAS 1	HAAS CNC VERTICA	AL MACHINING #1	0.00	と 9	13/10/	07		4	φ	•. -	0A3 08 8-8-
HAAS CNC vertical machin	number ar inspect as	art number and batch number programmed correctly.2-! per dwg D2933 & attached and visually inspect as per	er.1-Inspect part num Machine Step No 1 of	Folio and vis	ually						* Park
110	CONVENTIONAL MI	LLING MACHINE	0.00	h	13/10/0	\7		11	٦		08 08
110 Mill Conv	Memo	EELING WITCHING	0.00	7.55 (24)	Block	74	×		_φ		08
Conventional Milling Mach		Keyway and inspect per attac									
			,	X **							
	:.			,						·	
*120	QCI- Inspect dimension	ons to dimension sheet	0.00	D.8	13/10/0	7		4	d .		08
QC	Memo		0.00		•						o-89

Quality Control

											DQA	Date:	
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM	AANCE / UP	DATE	0.4.61	Data	-
										-	QA Closed	: Date:	
Work Orde	oř.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WORK OTCH	-					Rework	1 1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part I	No.					Scrap			Machining	Small Fab	Pro	od. Eng. Coor.	Quality
	-		· ·			Use-as-is	1 1		noforming	Finishing	1	re/Packaging	Other
NCR I	No.					Work Order Update			Large Fab	Composite		Supplier	
						<u> </u>							
Root					Descri	ption of work order update	1	Initial	Ac	ction	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data	Ш												
Equip/Tooling	Ш												
Operator	Ш												
Material	Ш												
Setup	Ш				İ		1						·
Other	Ш												
Process *	٠,٠												
Supplier													
Training	Ц												
Unapproved							<u> </u>				<u> </u>		
			· -			<u> </u>	AUL	T CATE	GORY				
Landi						General		7		_	7	 	n .
	\vdash	Bending				Bend	_	Grain			Ovalized	_	Pressure/Forced
to l	-	Centre No	ot Concer	ntric to	o/s	BOM/Route	<u></u>	Hardwa			Over/Unde		Temperature/Cure
క్ష	i-i	Cracks				Broken/Damaged	_	4 '	on Incomplete	<u> </u>	Part Incorre		Weld
	\vdash	Crushed/	Crimped			Burrs		1	ions Incomplete	/Unclear	Part Lost/N		Wrong Stock Pulled
	Щ	Cuffs				Contamination	_	Mainte			Part Moved		
	Ш	Heat Trea	t			Countersink		Mislabe	led		Positioned		7
	1 1	Inspection	n Strip in	Tube	I	Cut Too Short	1	Misread	d		Power Loss	/Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

Work Orde	
September-23-13	

Work Ord September-23-				*1()7	146*						Page 2
tem ID: Revision ID: Item Name:	D2933-2 206 Saddle Ri	ght		Accept	*N900	040	100)* s	etup Start	1.71	S1* S2*
Start Date: Required Date Reference:	9/23/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item II Customer:	D:				14	. 7/
Approvals:			Date:	Tooling: SPC (Y/N):		ite:		R	un Start Stop		R1* R2*
Sequence ID/ Work Center 1 130 *130* QC Quality Control	(D	Operation Description QC8- Inspect parts - second of	check	Set Up/ Run Hours 0.00	Tool ID	Tool# 3-10-0	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*140 *140* HandFinish Hand Finishing		Chemical Conversion Coat po	er QSI005 4.1	0.00				4	H	1 <u>3-10</u>	D <u>.</u>
*150 *150* Powdercoat Powder Coating	, , 5	White Gloss(Ref.4.3.5.1) per Memo START TIME: FIN	ISH TIME:	0.00 0.00 OVEN TEMPERATURE:			4	/χχ.	M	13/	10/06

m/26/25

											DQA:	Date	j:
NCR:	es /	No				WORK ORDER NON-C	100	NFORM	MANCE / UPI	DATE	QA Closed:	Date	a.
													· · · · · · · · · · · · · · · · · · ·
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
						Rework	1		Skid-tube	Crosstube] .	Water Jet	Engineering
Part N	10.					Scrap	1	ſ	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					<u> </u>	Use-as-is		Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo					Work Order Update]		Large Fab	Composite		Supplier	
<u> </u>	,											T	
Root						ption of work order update		initial		tion	Sign &	_	
Cause-	Di	ate	Step	Qty		or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data							}						
Equip/Tooling							İ						
Operator													
Material													
Setup													
Other													·
Process			,										
Supplier													
Training													
Unapproved													
						F	AUL	T CATE	GORY		-		
Landi	ng Gear					General		_		_	_	_	_
	Ben	ding				Bend		Grain			Ovalized		Pressure/Forced
:	Cen	tre Not	Concer	itric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Crac	ks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct _	Weld
	Crus	shed/Cr	imped			Burrs		Instruct	ions Incomplete/l	Jnclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuff	s				Contamination		Mainte	nance		Part Moved		

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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Work Orde	er ID 107146 B 11:09:51 AM		*107	7146*						Pag
Revision ID:	D2933-2 206 Saddle Right		Accept	*N900	040	100)* s	Setup Star Stop	14'2	1* 2*
Start Date: Required Date: Reference:	9/23/13 Start Qty: 4.00 9/23/13 Req'd Qty: 4.00	*4' *4'		Cust Item I Customer:	D:		_	0.		
Approvals:	Process Plan:	Date:	Tooling:	Da	ate:		F	Run Star	"NR	1*
,	QC:	Date:	SPC (Y/N):	D:	ate:			Stop	`*NR	2*
Sequence ID/ Work Center II 160 *160* QC Quality Control	Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00	Tool ID DAS 27 9-89 3-10-10	Tool#	Plan Code	Accept Qty	Reject Qty	-	isp. tamp
170 *170* Packaging Packaging	Identify as per dwg & Sto	ock Location: <u>57</u>	437 0.00 0.00				4x	DAS 28	13-10	-/

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

180

120

Quality Control

13/10/10. MF 10-10

Page 3

			DQA:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	
			0.4.61

,								·····-	QA Closed:	Date:	
Work Order					DISPOSITION			AGAINST DE	PARTMENT/	PROCESS	
Part No	D				Rework Scrap Use-as-is Work Order Update		Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	,			Descri	ption of work order update	Initial	Actio		Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Descri	ption	Date	Verification	QC Inspector
Ooc/Data											
quip/Tooling											
perator	_		*								
/latérial `	<u>. : </u>		- Ft								
etup											
Other	_						<u>-</u> .				
rocess											
iupplier	_	7									
raining			12								
Jnapproved			1								
					· · · · · · · · · · · · · · · · · · ·	AULT CATE	GORY				· · · · · · · · · · · · · · · · · · ·
Landin	g Gear			_	General		×.		1	_	7
_	Bendin	3 :		<u> </u>	Bend	Grain		<u> </u>	Ovalized		Pressure/Forced
	_	Not Conce	entric to	o/s	BOM/Route	Hardwa			Over/Under		Temperature/Cure
<u> </u>	Cracks			ļ	Broken/Damaged	—	ion incomplete		Part Incorrec) —	Weld
<u> </u>	_	d/Crimped	i	<u> </u>	Burrs	<u> </u>	tions Incomplete/U	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			L.	Contamination	⊢	enance	<u></u>	Part Moved		
L	Heat Ti			<u> </u>	Countersink	Mislabe		_	Positioned V		1
		ion Strip ir	n Tube		Cut Too Short	Misrea	d		Power Loss/	Surge	Other
		in Bend		<u> </u>	Drill Holes	Offset				ŧ.	
		Waves in		n L	Drawing		Calibration	•			
	 i	s Sequence			Finish	_	Sequence				,
	Wave/	Twist in Tu	ıbe	İ	Folio	Outside	e Dimensions				==

Date:

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Page 1

Work Order ID:

107146

Parent Item:

D2933-2

Parent Item Name:

206 Saddle Right

Start Date: 9/23/13

Required Date: 9/23/13

Start Qty: 4.00

Required Qty: 4.00

Comments: ·

IPP: B00.06.26New DWG rev (mpp 2069)EC IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001	parameter. A til til til till til til til til til ti	Manufactured	No			100	Each	38.0000	1	4	h	12	املمد
Saddle Billet									Community with the		_/7~ <i>⊌</i> _		10102
				Location		Loc Qty	<u>L</u> c	oc Code					
				MAT042		38							
				10363	37	3							
				97239)	27			_4.	٠٥			
				98456	5	8							

į.										DQA:	Date:	
NCR: Y	es / No		A ^c		WORK ORDER NON-O	CON	IFORM	MANCE / UPDATE		QA Closed:	Date:	
		 , ,			DISPOSITION			AGAINST	DE	PARTMENT/		
Work Order Part No	o				Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite		1	Water Jet J. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root				Descr	iption of work order update	Jr	nitial	Action		Sign &		
Cause '	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Description	-	Date	Verification	QC Inspector
Doc/Data						·	_					
Equip/Tooling						ŀ	κ.					
Operator												
Material			-	•	j.			*		1		
Setup				İ			•			1		
Other	7				4	5						
Process												
Supplier	7											
Training												
Unapproved					•							
					F	AUL7	T CATE	GORY				
Landin	g Gear				General						<u> </u>	
	Bending				Bend		Grain		L	Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
. [Cracks				Broken/Damaged .		Inspect	on Incomplete		Part Incorrec	t	Weld
	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
<u> </u>	Cuffs				Contamination	П	Mainte	nance		Part Moved		_
ľ	Heat Trea	at		<u> </u>	Countersink	П	Mislabe	led	Г	Positioned W	/rong	

Misread.

Out of Calibration
Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Ripples in Bend Torque Waves in Extrusion Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

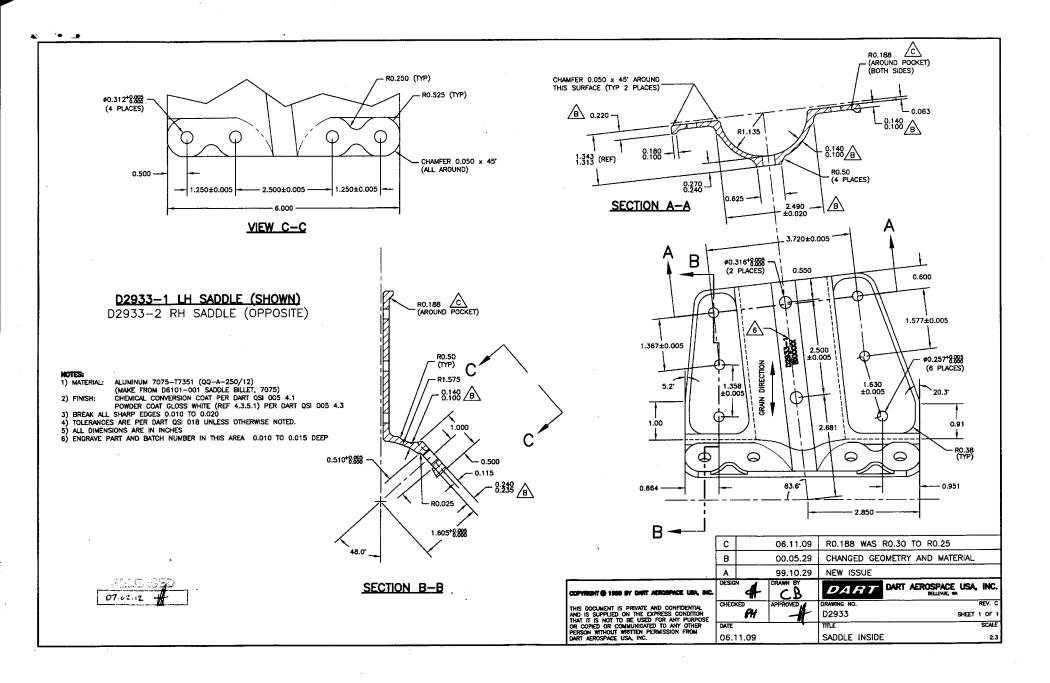
DART AEROSPACE LTD	Work Order:	107146
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Re	corded Actu	ıal Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.100	0.140		0.123	0.123	0.123	0.123		
В	0.100	0.140		0.123	0.123	0.173	0.123		
С	0.100	0.140		0.112	0.112	0.112	0.112		
D	0.210	0.230		0.222	0.222	0.222	0.222		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2-500	2.500		
Н	0.510	0.515		0.512	0.512	0.512	0.512		
1	1.572	1.582		1.577	1.577	1.577	1517		
J	2.495	2.505	_	2.500	2.500	2.500	2.500		
K	0.257	0.262		0.259	0.259	0.259	0.259		
L	0.312	0.317		0.314	0.314	0.314	0.314		
М	0.235	0.240		0.237	0.237	0.237	0.237		
N	0.100	0.140		0.120	0.119	0.20	0.120		
0	0.540	0.560		0.548	0.548	0.548	0.548		
Р	0.490	0.510		0.498	0.498	0.4198	0.498		
Q	3.715	3.725		3.720	3-720	3-720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2,490		
S	0.240	0.270		0.252	0.252	0.253	0.252		
Т	0.100	0.180		0.130	0.130	0.130	0.130		
Ü	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372	1	1.367	1.367	1.367	1,367		· · · · · · · · · · · · · · · · · · ·
w	0.316	0.321	~	0.316	0.316	0.316	0.316		
X	1.125	1.145	-	1.136	1136	1 12/6	1.136		
Ŷ	1.565	1.585	DT8695 A/B	1.574	1.136	1.136	1.574		
Z	0.178	0.198	B100007#B	0.188	881.0	0.188	0.188		
ĀĀ	3.113	3.700		- · · · · · · · · · · ·	V.100	0.100	0.100		
AB			 	-					
AC						<u> </u>			
AD									
AE			*	1	 	· ·		+	
AF									
AG				-			·····		
AH									
, 111	Acc	ept/Reje	oct						

	$\triangle \Delta $		1 1	<u> </u>
Measured by: 3.		Audited by	AL	
	10 107	Date:	17-10-67	
· · · · · · · · · · · · · · · · · · ·				

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	-1
С	07.03.21	Revised per drawing revision C	KJ/JLM 💉	



107146 MC5 13-09-24

